Quality Control

Work Orde Monday, April 1												Page 1
Item ID: Revision ID:	D3493-1			Accept					Setup			
Item Name:	Washer									Stop		
Start Date: Required Date:	4/11/2011 4/14/2011	Start Qty: 40.00 Reg'd Qty: 40.00			Cust Item I Customer:	D:						
Reference:			112-111 -1-11 11								I (BRILLING E	(B))
Approvals:	Process Pla	an:	Date://OH_//	Tooling: SPC (Y/N):		nte:	***************************************	1	Run	Start Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr		www.					•	***************************************		
D3493	Rev	/ A										
100 Hardinge		Hardinge CNC LATHE	SMALL	0.00	`			41	<u> </u>	D		
Hardinge CNC Lath	e Small		er Folio FA626 & Dwg D349	3 2-Debuter	118118							
110		QC2- Inspect parts off i	nachine FAI/FAIB	0.00	•			41	Q			
QC Quality Control		Мето		0.00	15/14							
		QC8- Inspect parts - sec	cond check	0.00	F 11.5-1	(8		4/	¢	,		
QC		Memo		0.00								

	-		* *	(ABI/ ABB=						
W/O: '			W	ORK ORDE	RCHANGE	<u> </u>				*
DATE	STEP	PROC	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										<i>:</i>
		÷			·				·	
Part No:		PAR #:	Fault Cat	tegory:		NCR: Yes	No DQ	A:	Date:	
	R	esolution:	_ Dispositi	ion:		QA: N/C C	losed:	1	Date:	
NCR:	•	W	ORK OR	DER NON-CO	ONFORMÁ	NCE (NC	₹)			
DATE	STEP	Description of NC	NC			on B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng		Description lef Eng	Sign of Date		ion C	Chief Eng	QC Inspector
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-										
					•					
					-					

Work Order ID 68253

Monday, April 11, 2011 10:30:50 AM



Page 2

Item ID:

D3493-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Washer

Start Qty: 40.00 4/11/2011

Operation

Description

Required Date: 4/14/2011

Req'd Qty: 40.00



Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop

Sequence ID/

Work Center ID

130

Packaging Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

N/5/19 95

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W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		2							
Part No		PAR #:	Fault Cate	egory:	NCR: Ye	s No C	QA:	Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C	Closed:		Date: _	
NCR:		V	WORK ORD	ER NON-CONFORM	ANCE (NO	R)			
DATE	STED	Description of NC		tion B	Ver	rification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& ∣ _S	ection C	Chief Eng	QC Inspector
		*							

Picklist Print

Monday, April 11, 2011 10:30:56 AM

Work Order ID: 68253

Parent Item:

D3493-1

Parent Item Name: Washer



Start Date: 4/11/2011

Required Date: 4/14/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev: A New Issue 06-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			100	f	65.8500	0.0291	1.225263	1/	Z/\Z	•

304 round bar 1.00

Location	Loc Oty	Loc Code
MAT029	65.85	
109508	12.5	
→ 109541	5.18	
113457	48.17	

1,4 Pt

2

W/O:			V	ORK ORDER CHANG	ES				t
DATE	STEP	PROCI	PROCEDURE CHANGE						Approval QC Inspector
Part No):	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	_ Date: _	
•	Re	solution:	Disposit	ion:	_ QA: N/C (Closed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA		R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign		cation	Approval	Approval
	0.2.	Section A	Chief Eng_	Action Description Chief Eng	Dat		tion C	Chief Eng	QC Inspector
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						:			

DART AEROSPACE LTD	Work Order:	68253
		7.
Description: Washer	Part Number:	D3493-1
Inspection Dwg: D3493 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	irst Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.192	+0.000/-0.005	.152			8-10	
Ø1.000	+/-0.010	0.895				
Ø0.958 x 100°	+/-0.010	D.588x108				
Ø0.516	+0.008/-0.001	0,516				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: /// 8	Date: 11, 6.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM	
В	06.11.22	Ø0.516 dimension removed	KJ/JLM 1.A	
С	08.04.30	Dimensions updated	KJ/DD ox	

W/O:	•		W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				•		•			
						•			
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	QA: N/C CI	osed:		Date: _	
NCR:		\	WORK ORE	ER NON-CONFORMAI	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
				1					



	DESIGN	PH	DRAWN BY	DART	AEROSPACE USA, INC.
ľ	CHECKED	M	APPROVED M	DRAWING NO.	REV. A
١		#	11	D3493	SHEET 1 OF 1
ľ	DATE		,	TITLE	SCALE
	06.01	.04		WASHER	1:1
T	Α		06.01.04	NEW ISSU	JE

SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4.5.3

All-04-11

Ø0.958X100*

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4.5.3

Ø0.516

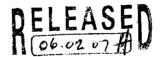
D3493-1 WASHER

D3493-1 WASHER

1) MATERIAL:

AISI 304/316 STAINLESS STEEL Ø1.000 ROUND BAR (REF DART MATERIAL SPEC M304R1.000)

- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX



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W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO		EDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				Kara and a second	-			+ 45	r	:'		
Part No	!	PAR #:	PAR #: Fault Category: No				No DQ	A :	Date:	<u>.</u> .		
			lution: Disposition: Q									
NCR:		V	WORK ORE	DER NON-CONFORMA	NCE (NCR)			_		
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Section			Approval	Approval		
	O I E I		Initial Chief Eng	Action Description Chief Eng	,	Date			Chief Eng	QC Inspector		
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[·] NOTE: Date & initial all entries